

Work Order ID 121314

Wednesday, July 30, 2014 4:25:46 PM

121314

Page 1

Item ID: D4464-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fuel Tank Assembly

Start Date: 6/24/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/24/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date: 14-7-30

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set-Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4464

F

Weld per dwg A/R Al

100

Large Fab

Large Fab

Achtung!
Vor Einbau Sicherungsstift herausnehmen
Attention,
remove safety pin before installation
Atenção!
Remova o pino de segurança antes de montar

Memo

1- Weld D4025

-110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

14-07-30
14-7-30

DQA:

Date: 14/12/23



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 14/12/16

Work Order update only ☐

Work Order: <u>121314</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4464-041</u>	Rework <input checked="" type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input checked="" type="checkbox"/>	
NCR No. <u>14-4486</u>	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input checked="" type="checkbox"/>	14/11/23	120	1	D4600-1 does not install with D4600-045. PART Needs to be angled two degrees. D4600-045 interferes with baffle, hole in baffle in wrong location. Design problem. RC Design issue	DAS 12 9-89 14/11/23	MAKE ANGLED SHIM TO match orientation of D4600-045. 6061-T6 ROUND BAR B/N 101699. Install with pin and longer rivets as req. After Remove plastic grommet and enlarge hole in baffle as req'd to clear D4600-045. Take up and keep and ensure there are no chips in tank	JK 14-12-8 14/12/08 DAS 36 9-89	DAS 38 9-89 DEC 08 2014	
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input checked="" type="checkbox"/> Other
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	

Design issue

Work Order ID 121314

June-24-14 8:56:49 AM

121314

Page 2

Item ID: D4464-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Tank Assembly
 Start Date: 6/24/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/24/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
112		0.00							
112						<u>1X</u>			<u>14/07/30</u>
Small Fab	Memo	0.00							
Small Fab	1- Install hinge wet with proseal as per dwg A/R Proseal Batch: <u>M128638</u>								
	2- Wet install baffles to front and back panel using rivet and Proseal as per dwg A/R Proseal Batch: <u>M128638</u>								
114	QC5- Inspect part completeness to step on W/O	0.00							
114									
QC	Memo	0.00							
Quality Control									<u>14.08.06</u>

DAS
36
9-89

Work Order ID 121314

June-24-14 8:56:49 AM

121314

Page 3

Item ID: D4464-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fuel Tank Assembly
 Start Date: 6/24/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/24/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Weld per dwg A/R Aluminum rod Batch: <u>128756</u>	0.00				1x			14/11/26

120

Large Fab

Large Fab

Memo

0.00

- 1- Weld D4001-1 and D4000-5 onto D4463-1 Top
- 2- Weld D3999-041/-043 doubler, ensure doubler and angle holes line-up for D4000-047
Transfer drill and c'sink D4975-1 bracket to bottom bracket, wet install as per dwg

Proseal Batch: M130090

- 3- Weld D4000-043 and D4000-045 on tank as per dwg.

- 4- Instal D4000-9 grommets as per dwg, Weld D4463-3 aft end as per dwg, locate D4000-1 and wet install with rivets as per dwg

Proseal Batch: M130090

- 5-Weld D4463-7 fwd end

PURGE INSIDE OF TANK

- 6-Weld top D4463-1 using DT9811 and DT9810

PURGE INSIDE OF TANK

Cpl 14.12.03

DAS
36
9-89

Work Order ID 121314

121314

Page 4

June-24-14 8:56:49 AM

Item ID: D4464-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fuel Tank Assembly
Start Date: 6/24/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/24/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123	QC5- Inspect part completeness to step on W/O	0.00							
123									DAS
QC	Memo	0.00							9
Quality Control	***Pressure Test as per dwg D4464***								9-89
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
140									DAS
QC	Memo	0.00							9
Quality Control									9-89
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing	1- brush alodine on tank. No alodine inside								

1 CP 14.12.3

June-24-14 8:56:49 AM

121314

Page 5

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Fuel Tank Assembly

Start Date: 6/24/14 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/24/14 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------------	---------------	------------------	----------------

160

QC7-Inspect Chemical Conversion Coat

0.00

160

OC

Memo

0.00

Quality Control

164

0.00

164

Small Fab

Memo

0.00

Small Fab

1- Wipe with clean cloth and wash and wipe

2- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890

A/R Proseal 890 Batch: *1130090*

166

QC5- Inspect part completeness to step on W/O	0.00
---	------

166

OC

Memo

0.00

Quality Control

① 14.12.04 PD

IX 14/12/04 DAS 36 9-89

① 14.12.06 DAS 9 9-89

Work Order ID 121314

June-24-14 8:56:49 AM

121314

Page 6

Item ID: D4464-041 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Fuel Tank Assembly

Start Date: 6/24/14 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 6/24/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170									
SprayPaint	Memo	0.00							
Spray Painting	***MASK PROIOR PRIME AND PAINT***								
	PRIME TEMPO GREY AS PER DWG AND OSI								
	PRIMER BATCH: m126522								
	PAINT GREY AS PER DWG AND OSI								
	PAINT BATCH: m127810								
180	QC14- Inspect Spray Paint	0.00							
180									
QC	Memo	0.00							
Quality Control									

1
CR 14-12-07

0 14-12-00

DAS 9 9-89

DAS 38 9-89

Work Order ID 121314

121314

Page 7

June-24-14 8:56:49 AM

Item ID: D4464-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fuel Tank Assembly
 Start Date: 6/24/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/24/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
190									
Small Fab	Memo	0.00							
Small Fab	1- Mask off area, where access cover is applied								
	2- Abrade surface with red scotch brite								
	3- Assemble as per dwg								
	4- Install cushion using contact cement								
	A/R Contact Cement Batch: 1300L M131012								
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									

DAS
36
9-89

DAS
22
9-89
14-12-08

① 14-12-08 ①

Work Order ID 121314

June-24-14 8:56:49 AM

121314

Page 8

Item ID: D4464-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fuel Tank Assembly
 Start Date: 6/24/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/24/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location	0.00							
210									
Packaging	Memo	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

Handwritten notes: 127067, DEC 09 2014, DAS, 14-12-09, W4-12-09

Picklist Print

June-24-14 8:56:53 AM

Page 1

13

Work Order ID: 121314

121314

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B
12.03.08 AS PER DWG REV.B DD VERF:EC IPP REV:C 12.04.24
ECN 12-571 DD VERF:EC IPP REV:D 13.10.30 DWG
REV PE1 DD VERF:JLM IPP REV:E 14.06.13 AS PER DWG
REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3997-5

D3997-5

Placard

Manufactured

No

190

Each

63.0000

2

2

**

14/12/08

DAS
36
9-89

Location

Loc Qty

Loc Code

ST244A

63

72611

63

2

D3997-11

D3997-11

Placard

Manufactured

No

190

Each

24.0000

1

1

**

14/12/08

DAS
36
9-89

Location

Loc Qty

Loc Code

ST244A

24

106884

12

107679

9

99791

3

1

D3997-17

D3997-17

Placard

Manufactured

No

190

Each

21.0000

1

1

**

14/12/08

DAS
36
9-89

Location

Loc Qty

Loc Code

ST244A

21

100181

5

106785

7

107632

9

1

Picklist Print

June-24-14 8:56:53 AM

Page 2

Work Order ID: 121314

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

121314

D4464-041

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

D3997-29
D3997-29
Placard

Manufactured No

190 Each 13.0000 1 1

**

14/12/08

DAS
36
9-89

Location

Loc Qty

Loc Code

ST244A

13

100182

2

106864

11

Manufactured No

190 Each 24.0000 1 1

**

14/12/08

DAS
36
9-89

Location

Loc Qty

Loc Code

ST244A

24

100183

4

106642

10

107558

9

82960

1

Manufactured No

120 Each 17.0000 1 1

**

CPC 14-11-27

Location

Loc Qty

Loc Code

WA003

17

108621

17

Manufactured No

120 Each 5.0000 1 1

**

CPC 14-11-27

Location

Loc Qty

Loc Code

prelim

5

120690

5

B 122-448

D3999-7
D3999-7
Corner

Manufactured No

120 Each 17.0000 1 1

**

CPC 14-11-27

D4000-1
D4000-1
Fuel Supply Fitting

Manufactured No

120 Each 5.0000 1 1

**

CPC 14-11-27

June-24-14 8:56:53 AM

Shop Packet Print

Page 2

Picklist Print

June-24-14 8:56:53 AM

Page 3

Work Order ID: 121314

121314

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

D4000-5 Manufactured No

120 Each 18.0000 1 1

D4000-5

Fuel Tank Vent Fitting

PC 14.11.27

B121131 → 1

Location

Loc Qty

Loc Code

WA003

18

100528

3

106917

9

107388

6

D4000-9 Manufactured No

120 Each 54.0000 3 3

D4000-9

Grommet

14.08.07

Location

Loc Qty

Loc Code

WA003

54

105466

16

106808

38

D4000-045 Manufactured No

120 Each 8.0000 1 1

D4000-045

Fuel Pickup Fitting Assembly

14/11/25 DAS 36 9-89

Location

Loc Qty

Loc Code

WA003

8

106873

2

107357

4

111048

2

Manufactured No

120 Each 0.0000 1 1

D4008-11

Hinge Half

14/12/08 DAS 36 9-89

*B121802
(1X)*

June-24-14 8:56:53 AM

Shop Packet Print

Page 3

Picklist Print

June-24-14 8:56:53 AM

Page 4

Work Order ID: 121314

121314

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

D4008-041

Manufactured No

190

Each

13.0000

1

1

DAS

36

9-89

D4008-041

Fuel Filler Splash Guard Assembly

Location

Loc Qty

Loc Code

ST108

7

107372

7

ST242A

6

106901

6

Each

7.0000

1

D4023-1

Manufactured No

D4023-1

Cap And Flange

Location

Loc Qty

Loc Code

Mezz

7

64879

6

66862

1

190

Each

19.0000

1

1

D4023-3

Manufactured No

D4023-3

Cap And Flange

Location

Loc Qty

Loc Code

ST143

14

106700

10

107201

2

84422

2

WA003

5

120208

5

June-24-14 8:56:54 AM

Shop Packet Print

Page 4

Picklist Print

June-24-14 8:56:54 AM

Page 5

Work Order ID: 121314

121314

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

Manufactured No

190

Each

15.0000

1

1

Cpl 14.11.27
14/12/08

DAS
36
9-89

D4025-5

D4025-5

Fuel Quantity Sender

Location

Loc Qty

Loc Code

ST140

15

106832

10

107655

5

Manufactured No

120

Each

94.0000

3

3

14.08.07

D4057-1

D4057-1

Retaining Ring

Location

Loc Qty

Loc Code

WA003

94

106766

47

107269

47

Manufactured No

190

Each

12.0000

1

1

14/12/08

DAS
36
9-89

D4062-041

D4062-041

Tank Support Assembly

Location

Loc Qty

Loc Code

WA003

12

100076

2

106669

1

107170

5

90627

4

Manufactured No

120

Each

32.0000

4

4

Cpl 14.11.27

D4124-1

D4124-1

Tab

Location

Loc Qty

Loc Code

WA003

32

100079

7

106845

5

107333

20

June-24-14 8:56:54 AM

Shop Packet Print

Page 5

Picklist Print

June-24-14 8:56:54 AM

Work Order ID: 121314

121314

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

D4125-1

Manufactured No

120

Each

10.0000

1

1

D4125-1

Sump

14.07.15

Location

Loc Qty

Loc Code

WA003

10

106764

3

107267

2

110961

3

99890

2

D4125-3

Manufactured No

120

Each

13.0000

1

1

D4125-3

End

14.07.16

Location

Loc Qty

Loc Code

WA003

13

106826

3

111009

3

114307

5

99891

2

D4404-5

Manufactured No

120

Each

7.0000

2

2

D4404-5

Cushion, Fwd

14/12/08 **DAS 36 9-89**

Location

Loc Qty

Loc Code

ST145

7

102143

6

99743

1

D4462-1

Manufactured No

112

Each

6.0000

1

1

D4462-1

Baffle

14.7.16

Location

Loc Qty

Loc Code

WA

6

121109

6

121108
(14)

June-24-14 8:56:54 AM

Shop Packet Print

Picklist Print

June-24-14 8:56:54 AM

Page 7

Work Order ID: 121314

121314

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

D4462-3	Manufactured	No	112	Each	6.0000	1	1
---------	--------------	----	-----	------	--------	---	---

D4462-3

Baffle

**

Cpl 14.8.7

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	6	
121158	6	

D4463-041	Manufactured	No	120	Each	4.0000	1	1
-----------	--------------	----	-----	------	--------	---	---

D4463-041

Tank Top Assembly

**

B121666 (10)
Cpl 14.11.27
B122884 → 1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA003	4	
120921	4	

D4463-3	Manufactured	No	120	Each	4.0000	1	1
---------	--------------	----	-----	------	--------	---	---

D4463-3

Tank Aft End

**

Cpl 14.11.27
B123813 → 1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA003	4	
120922	4	

D4463-5	Manufactured	No	120	Each	5.0000	1	1
---------	--------------	----	-----	------	--------	---	---

D4463-5

Tank Upper Cut Out

**

Cpl 14.08.7

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA003 <i>B106751</i>	5	
120923	5	

D4463-7	Manufactured	No	120	Each	0.0000	1	1
---------	--------------	----	-----	------	--------	---	---

D4463-7

Tank Fwd End

**

Cpl 14.11.27
B121172 → 1

June-24-14 8:56:54 AM

Shop Packet Print

Page 7

Picklist Print

June-24-14 8:56:54 AM

Page 8

Work Order ID: 121314

121314

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

D4463-9 Manufactured No 112 Each 4.0000 1 1

D4463-9

Tank Back

14.07.28

Location

Loc Qty

Loc Code

WA

3121175

4

120925

4

D4463-11 Manufactured No 112 Each 6.0000 1 1

D4463-11

Tank Front

14.07.15

Location

Loc Qty

Loc Code

WA003

6

121168

6

D4463-13 Manufactured No 190 Each 5.0000 1 1

D4463-13

Tank Bottom

14.07.16

Location

Loc Qty

Loc Code

WA003

5

111589

1

120926

4

D4577-041- Manufactured No 190 Each 20.0000 1 1

D4577-041

Fwd Access Panel Assembly

14/12/04 DAS
36
9-89

Location

Loc Qty

Loc Code

ST142

20

106703

20

June-24-14 8:56:54 AM

Shop Packet Print

Page 8

Picklist Print

June-24-14 8:56:54 AM

Page 9

Work Order ID: 121314

121314

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

D4577-1
D4577-1
Rear Access Panel

Manufactured No

190 Each 9.0000 1 1

**

14/12/04
36
9-89

Location

Loc Qty

Loc Code

ST142

9

106923

9

Manufactured No

190 Each 9.0000 1 1

**

14/12/04
36
9-89

Location

Loc Qty

Loc Code

ST142

9

106697

8

107197

1

Manufactured No

190 Each 11.0000 1 1

**

14/12/08
36
9-89

Location

Loc Qty

Loc Code

ST232A

11

120927

11

Manufactured No

Each 11.0000 1

**

14/12/08
36
9-89

Location

Loc Qty

Loc Code

st128

11

120928

11

D4968-1
D4968-1
Side Cushion

D4975-1
D4975-1
Bracket

June-24-14 8:56:55 AM

Shop Packet Print

Page 9

Picklist Print

June-24-14 8:56:55 AM

Page 11

Work Order ID: 121314

121314

Parent Item: D4464-041

D4464-041


Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

 AN3-5A
AN3-5A
Bolt

Purchased

No

Each

424.0000

5

**

36
9-89

14/12/08

AN3H5A

Location

Loc Qty

Loc Code

GA

45

117423

45

ST350

150

m129507

150

ST511

169

m126559

92

m129246

77

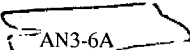
ST512

60

124561

60

M125445
(52)

 AN3-6A

AN3-6A
Bolt

Purchased

No

190

Each

317.0000

4

4

**

DAS
36
9-89

14/12/08

Location

Loc Qty

Loc Code

ST351

313

116390

11

M128403

2

M128739

150

M128978

150

ST511

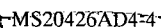
4

M127044

4

4

~~M12115740~~

 MS20426AD4-4

MS20426AD4-4
Rivet

Purchased

No

Each

2,913.000

4

**

DAS
36
9-89

14/12/08

Location

Loc Qty

Loc Code

GA

169

129090

169

ST334

2744

125445

2744

4

June-24-14 8:56:55 AM

Shop Packet Print

Page 11

Picklist Print

June-24-14 8:56:55 AM

Page 12

Work Order ID: 121314

121314

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-6

Purchased

No

Each

2,791.000

8

MS20426AD4-6

Rivet

Location

Loc Qty

Loc Code

MF4

52

124392

52

ST334

852

124392

852

ST336

1887

M128812

1887

MS20470AD4-4

Purchased

No

Each

3,583.000

165

MS20470AD4-4

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST312

3583

118614

27

121652

180

M128401

1736

M128754

66

M129499

1574

MS21042L3

Purchased

No

190

Each

5,662.000

4

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST307

5662

108816

1

123900

955

M126333

55

M127410

13

M127831

41

M128401

48

M128754

4549

14/07/30

DAS

36

9-89

165

14/12/08

DAS

36

9-89

4

June-24-14 8:56:55 AM

Shop Packet Print

Page 12

Picklist Print

June-24-14 8:56:55 AM

Page 13

Work Order ID: 121314

121314

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/24/14

Required Date: 6/24/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

190

Each

3,032.000

5

**

NAS1149D0332.J

Washer

Location

Loc Qty

Loc Code

ST276

3032

m128606

253

m128612

2779

NAS1149D0363J

Purchased

No

190

Each

3,382.000

32

**

NAS1149D0363.J

Washer

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

3359

m126319

6

m128429

3353

4

14/12/08

M130325 (4x)

14/12/04

DAS
36
9-89

32

NAS1149D0316 J

DAS
22
9-89

14-12-08

1x

M127956

14/12/08

June-24-14 8:56:56 AM

Shop Packet Print

Page 13

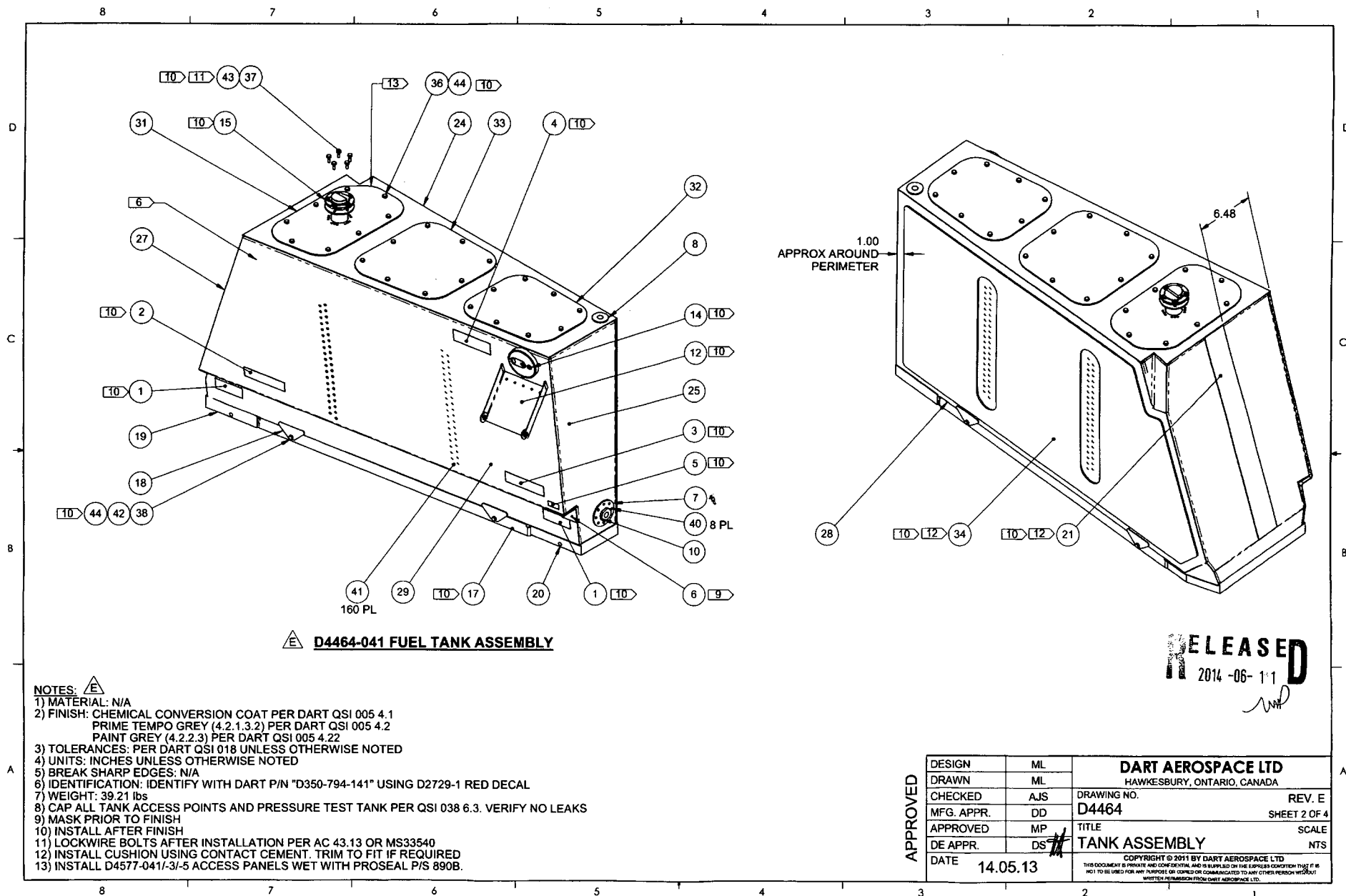
ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D4464-041	FUEL TANK ASSEMBLY
1	2	D3997-5	PLACARD (AUX FUEL DRAIN)
2	1	D3997-11	PLACARD (LOADING)
3	1	D3997-17	PLACARD (STOWAGE)
4	1	D3997-29	PLACARD (WARNING)
5	1	D3997-43	PLACARD (EARTH)
6	1	D3999-7	CORNER
7	1	D4000-1	FUEL SUPPLY FITTING
8	1	D4000-5	FUEL TANK VENT FITTING
9	3	D4000-9	GROMMET
10	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
11	1	D4008-11	TANK HINGE HALF
12	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
13	1	D4023-1	FUEL CAP FLANGE
14	1	D4023-3	FUEL CAP
15	1	D4025-5	FUEL SENDER
16	3	D4057-1	RETAINER
17	1	D4062-041	TANK SUPPORT
18	4	D4124-1	TAB
19	1	D4125-1	FWD SEDIMENT BOWL
20	1	D4125-3	AFT SEDIMENT BOWL
21	2	D4404-5	CUSHION, FWD
22	1	D4462-1	BAFFLE
23	1	D4462-3	BAFFLE
24	1	D4463-041	TOP TANK ASSEMBLY
25	1	D4463-3	TANK AFT END
26	1	D4463-5	TANK UPPER CUT OUT
27	1	D4463-7	TANK FORWARD END
28	1	D4463-9	TANK BACK
29	1	D4463-11	TANK FRONT
30	1	D4463-13	TANK BOTTOM
31	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
32	1	D4577-1	REAR ACCESS PANEL
33	1	D4577-3	MIDDLE ACCESS PANEL
34	1	D4968-1	CUSHION, SIDE
35	1	D4975-1	ANGLE BRACKET
36	24	AN3C4A	BOLT
37	5	AN3-5A	BOLT
38	4	AN3-6A	BOLT
39	4	MS20426AD4-4	RIVET, SOLID, CSK
40	8	MS20426AD4-6	RIVET, SOLID, CSK
41	165	MS20470AD4-4	RIVET, SOLID, PAN HEAD
42	4	MS21042L3	NUT
43	5	NAS1149D0332J	WASHER
44	32	NAS1149D0363J	WASHER

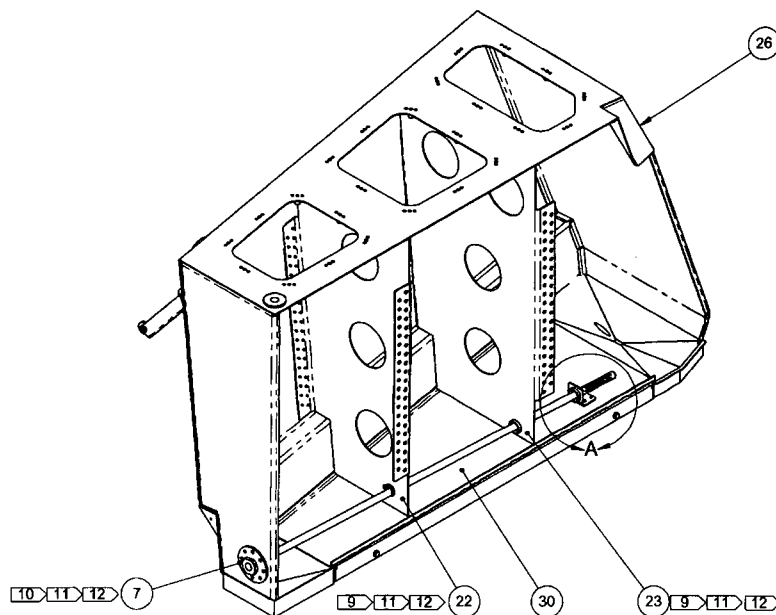
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121314 MLJ
1406-24

RELEASED
2014-06-11
MD

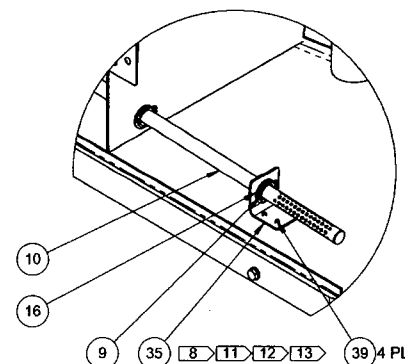
E	UPDATED -041 WITH RE-DESIGNED D4463-3/-9/-11 AND D4462-1/-3 D4968-1 REPLACES D4404-5 ON TANK SIDE (ZN C3-2) REF NCR 13-3100 AN3-6A REPLACES MS35206-266 (ZN B8-2) NAS1149D0332J REPLACES 5 X NAS1149D0363J (ZN D7-2) REF PAR 12-217 D4975-1 REPLACES D3999-9 (ZN C3-2) REMOVED TAB D3999-11 AND MOVED D3997-43 PLACARD (ZN B6-5) UPDATED BILL OF MATERIALS REVISED ALL NOTES REMOVED SHEET 5	ML	14.05.13
D	ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4.	DC	12.05.02
C	UPDATED -041 WITH RE-DESIGNED D4463-11/-13 REV. C PARTS, ZN B6-2, UPDATED -041 WITH RE-DESIGNED D4577-041/-3/-5 PARTS, ZN C6-2.	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS, REMOVED D4463-13, ADDED D4577-041/-1/-5 ACCESS PANELS, ZN C6-2.	DC	11.12.14
A	NEW ISSUE, REF PAR11-117 & CAR 11-54.	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	DD	D4464	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
DATE	14.05.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED





D4464-041 FUEL TANK ASSEMBLY
D4463-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A
ROTATED FOR CLARITY
SCALE 2X

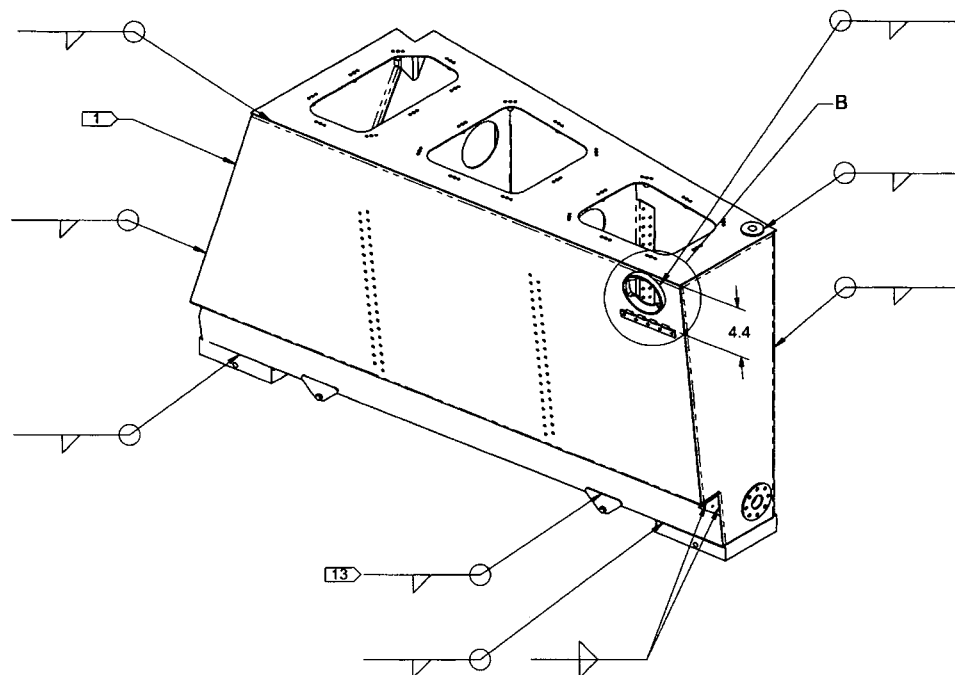
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 39.21 lbs
- 8) COAT FAYING SURFACES OF D4975-1 ANGLE BRACKET AND D4463-13 TANK BOTTOM WITH PROSEAL P/S 890B AND WET INSTALL MS20426AD4-4 RIVETS
- 9) COAT FAYING SURFACES OF D4462-1/-3 BAFFLES AND D4463-9/-11 TANK FRONT/BACK WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
- 10) COAT FAYING SURFACES OF D4000-1 FUEL SUPPLY FITTING AND D4463-3 TANK AFT END WITH PROSEAL P/S 890B AND WET INSTALL MS20426AD4-6 RIVETS
- 11) FILLET SEAL THE INTERIOR OF THE TANK AROUND THE EDGE OF D4975-1 ANGLE BRACKET, D4462-1/-3 BAFFLES AND D4000-1 FUEL SUPPLY FITTING WITH PROSEAL P/S 890B
- 12) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B
- 13) TRANSFER DRILL $\phi 0.128$ HOLES FROM D4975-1 ANGLE BRACKET INTO D4463-13 TANK BOTTOM AND COUNTERSINK HOLES $\phi 0.225 \times 100^\circ$ FROM THE OUTSIDE OF THE TANK

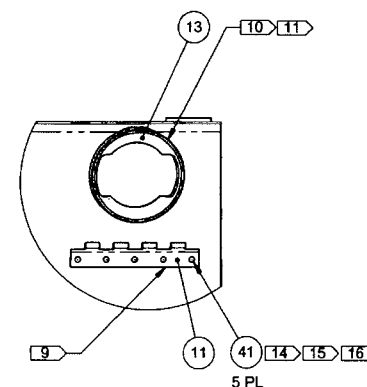
RELEASED
2014-06-11

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO. D4464	REV. E
MFG. APPR.	DD		SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
DATE	14.05.13	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4464-041 FUEL TANK ASSEMBLY
WELDING AND RIVETING DETAIL



DETAIL B
ROTATED FOR CLARITY
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 9) CENTER HINGE BELOW FUEL CAP FLANGE
- 10) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 11) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 12) WELD PER DART QSI 004
- 13) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING
D4124-1 TABS MAY BE HAND FORMED AS REQUIRED TO FIT D4062-041 ASSEMBLY BEFORE WELDING
- 14) COAT FAYING SURFACES OF D4008-11 TANK HINGE HALF AND D4463-11 TANK FRONT WITH PROSEAL P/S 890B
AND WET INSTALL MS20470AD4-4 RIVETS
- 15) FILLET SEAL THE INTERIOR OF THE TANK AROUND THE EDGE OF THE BAFFLES WITH PROSEAL P/S 890B
- 16) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	DD	D4464	SHEET 4 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	D6	TANK ASSEMBLY	NTS
DATE	14.05.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

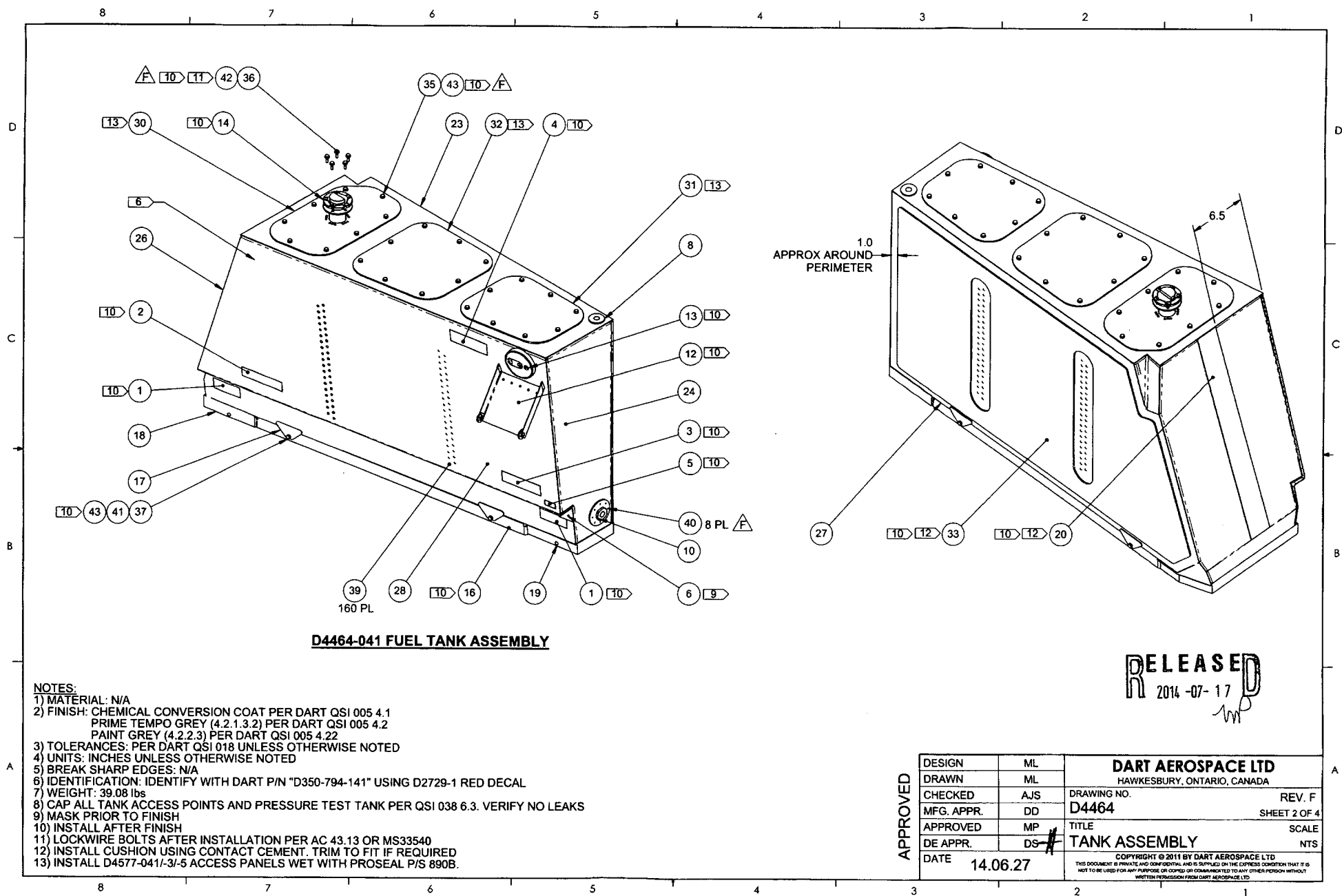
RELEASED
2014-06-11

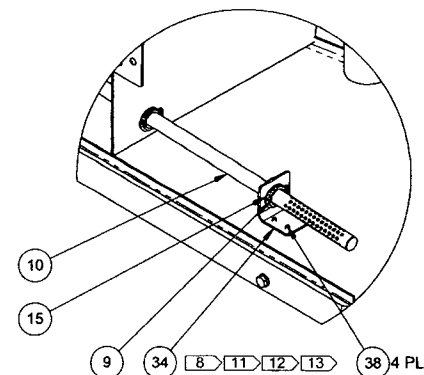
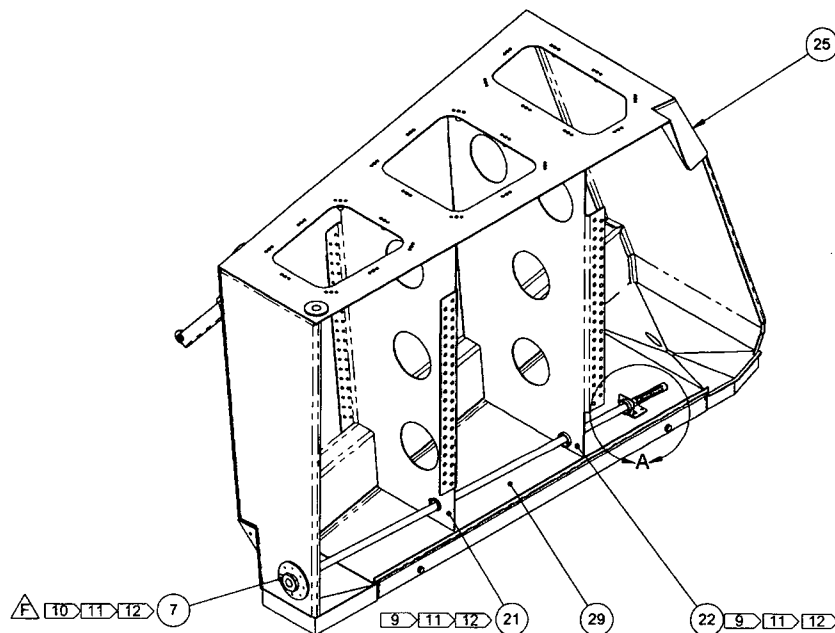
ITEM	QTY -041	PART NUMBER	DESCRIPTION
	X	D4464-041	FUEL TANK ASSEMBLY
1	2	D3997-5	PLACARD (AUX FUEL DRAIN)
2	1	D3997-11	PLACARD (LOADING)
3	1	D3997-17	PLACARD (STOWAGE)
4	1	D3997-29	PLACARD (WARNING)
5	1	D3997-43	PLACARD (EARTH)
6	1	D3999-7	CORNER
7	1	D4000-1	FUEL SUPPLY FITTING
8	1	D4000-5	FUEL TANK VENT FITTING
9	3	D4000-9	GROMMET
10	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
11	1	D4008-11	TANK HINGE HALF
12	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
13	1	D4023-3	FUEL CAP AND FLANGE
14	1	D4025-5	FUEL SENDER
15	3	D4057-1	RETAINER
16	1	D4062-041	TANK SUPPORT
17	4	D4124-1	TAB
18	1	D4125-1	FWD SEDIMENT BOWL
19	1	D4125-3	AFT SEDIMENT BOWL
20	2	D4404-5	CUSHION, FWD
21	1	D4462-1	BAFFLE
22	1	D4462-3	BAFFLE
23	1	D4463-041	TOP TANK ASSEMBLY
24	1	D4463-3	TANK AFT END
25	1	D4463-5	TANK UPPER CUT OUT
26	1	D4463-7	TANK FORWARD END
27	1	D4463-9	TANK BACK
28	1	D4463-11	TANK FRONT
29	1	D4463-13	TANK BOTTOM
30	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
31	1	D4577-1	REAR ACCESS PANEL
32	1	D4577-3	MIDDLE ACCESS PANEL
33	1	D4968-1	CUSHION, SIDE
34	1	D4975-1	ANGLE BRACKET
35	24	AN3-5A	BOLT
36	5	AN3H5A	BOLT
37	4	AN3-6A	BOLT
38	4	MS20426AD4-4	RIVET, CSK
39	165	MS20470AD4-4	RIVET, PANHEAD
40	8	MS20470AD4-6	RIVET, PANHEAD
41	4	MS21042L3	NUT
42	5	NAS1149D0332J	WASHER
43	32	NAS1149D0363J	WASHER

RELEASED
2014-07-17

F	AN3-5A WAS AN3C4A QTY. 24 (ZN D6-2) AN3H5A WAS AN3-5A QTY. 5 (ZN D7-2) MS20470AD4-6 WAS MS20426AD4-6 QTY. 8 (ZN B5-2) D4000-1 IS NO LONGER INSTALLED WITH COUNTERSUNK RIVETS UPDATE NOTE 10 ON SHEET 3	ML	14.06.27
E	UPDATED -041 WITH RE-DESIGNED D4463-3/-9/-11 AND D4462-1/-3. D4968-1 REPLACES D4404-5 ON TANK SIDE (ZN C3-2) REF NCR 13-3100 AN3-6A REPLACES MS35206-266 (ZN B8-2) NAS1149D0332J REPLACES 5 X NAS1149D0363J (ZN D7-2) REF PAR 12-217 D4975-1 REPLACES D3999-9 (ZN C3-2) REMOVED TAB D3999-11 AND MOVED D3997-43 PLACARD (ZN B6-5) UPDATED BILL OF MATERIALS REVISED ALL NOTES REMOVED SHEET 5	ML	14.05.13
D	ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4.	DC	12.05.02
C	UPDATED -041 WITH RE-DESIGNED D4463-11/-13 REV. C PARTS, ZN B6-2. UPDATED -041 WITH RE-DESIGNED D4577-041/-3/-5 PARTS, ZN C6-2.	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS. REMOVED D4463-13. ADDED D4577-041/-1/-5 ACCESS PANELS, ZN C6-2.	DC	11.12.14
A	NEW ISSUE. REF PAR11-117 & CAR 11-54.	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. F
MFG. APPR.	DD	D4464	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
DATE	14.06.27	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

APPROVED





D4464-041 FUEL TANK ASSEMBLY
D4463-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL

DETAIL A
ROTATED FOR CLARITY
SCALE 2X

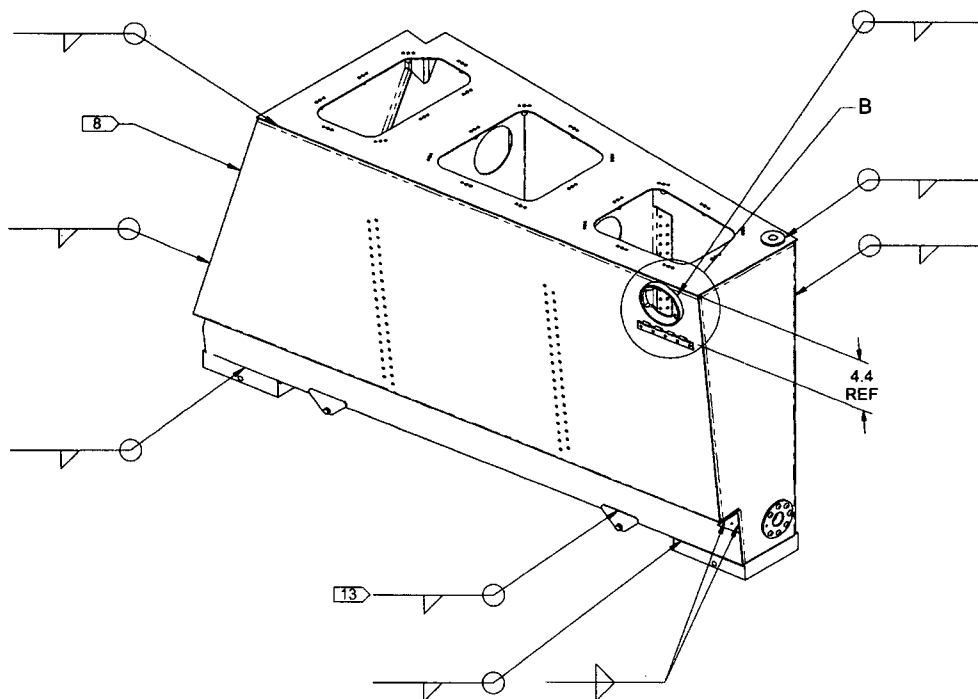
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) COAT FAYING SURFACES OF D4975-1 ANGLE BRACKET AND D4463-13 TANK BOTTOM WITH PROSEAL P/S 890B AND WET INSTALL MS20426AD4-4 RIVETS
- 9) COAT FAYING SURFACES OF D4462-1/-3 BAFFLES AND D4463-9/-11 TANK FRONT/BACK WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
- 10) COAT FAYING SURFACES OF D4000-1 FUEL SUPPLY FITTING AND D4463-3 TANK AFT END WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-6 RIVETS
- 11) FILLET SEAL THE INTERIOR OF THE TANK AROUND THE EDGE OF D4975-1 ANGLE BRACKET, D4462-1/-3 BAFFLES AND D4000-1 FUEL SUPPLY FITTING WITH PROSEAL P/S 890B
- 12) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B
- 13) TRANSFER DRILL $\phi 0.128$ HOLES FROM D4975-1 ANGLE BRACKET INTO D4463-13 TANK BOTTOM AND COUNTERSINK HOLES $\phi 0.225 \times 100^\circ$ FROM THE OUTSIDE OF THE TANK

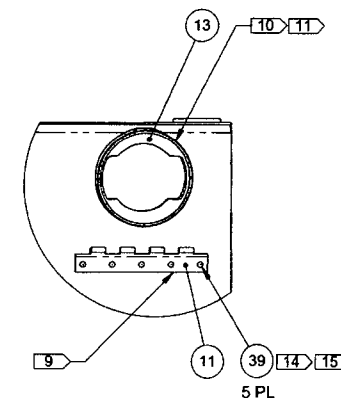
RELEASED
2014-07-17

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. F
MFG. APPR.	DD	D4464	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
DATE	14.06.27	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4464-041 FUEL TANK ASSEMBLY
WELDING AND RIVETING DETAIL



DETAIL B
ROTATED FOR CLARITY
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 9) CENTER HINGE BELOW FUEL CAP FLANGE
- 10) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 11) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 12) WELD PER DART QSI 004
- 13) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING
D4124-1 TABS MAY BE HAND FORMED AS REQUIRED TO FIT D4062-041 ASSEMBLY BEFORE WELDING
- 14) COAT FAYING SURFACES OF D4008-11 TANK HINGE HALF AND D4463-11 TANK FRONT WITH PROSEAL P/S 890B
AND WET INSTALL MS20470AD4-4 RIVETS
- 15) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B

RELEASED
2014-07-17

APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. F
MFG. APPR.	DD	D4464	SHEET 4 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
DATE	14.06.27	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	